



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2739

Job Sheet 178793



Part No: D2739

Job Qty: 10 ea

Part Name: 350 I-Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 6/7/18

Job Tracking No:

Due Date: 6/13/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG D2739 REV E IPP Rev: C 02.11.28 Reformat KJ IPP Rev: D 06-03-21 As Per Rev C JLM IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F 10.11.02 as per revE DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		6/13/18	0.00	0.00	Start Up Skid tubes-2		
100	Skid tubes	10 pcs		6/13/18	0.00	5.41	Skid tubes-3		
120	HandFinish	10 pcs		6/13/18	0.00	0.83	HandFinish1		
130	QC	10 pcs		6/13/18	0.00	0.00	QC5		
140	Packaging	10 pcs		6/13/18	0.00	0.00	Packaging3-1		
150	QC21-SA	10 Ea		6/13/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 3-Descriptions: Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends.

140 - LOCATION : LG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-5-108	Extrusion I-Beam Thin	10 Ea (1 ea)	90-Start up Operation	B 145248

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-5-108	10	79	0



Container No: S079760



Part: D2739

Job No: 178793

Serial No/Batch: S079760

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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Date: 06/11/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Web	78.760Inches $\pm$ 0.030	78.790 78.730		
2	Web	1.180Inches $\pm$ 0.010	1.190 1.170		
3	Web	3.150Inches $\pm$ 0.010	3.160 3.140		
4	Web	1.180Inches $\pm$ 0.010	1.190 1.170		
5	Web	0.250Inches $\pm$ 0.030	0.280 0.220		
6	Web	30.000Degrees + 0.500 - 5.000	30.500 25.000	Angle	
7	Web	1.250Inches $\pm$ 0.030	1.280 1.220		
8	Web	7.880Inches $\pm$ 0.030	7.910 7.850		
9	Web	10.070Inches $\pm$ 0.030	10.100 10.040		
10	Web	12.990Inches $\pm$ 0.030	13.020 12.960		
11	Web	16.540Inches $\pm$ 0.030	16.570 16.510		
12	Web	20.870Inches $\pm$ 0.030	20.900 20.840		
13	Web	25.200Inches $\pm$ 0.030	25.230 25.170		
14	Web	29.530Inches $\pm$ 0.030	29.560 29.500		
15	Web	32.650Inches $\pm$ 0.030	32.680 32.620		
16	Web	33.860Inches $\pm$ 0.030	33.890 33.830		
17	Web	35.350Inches $\pm$ 0.030	35.380 35.320		
18	Web	38.280Inches $\pm$ 0.030	38.310 38.250		
19	Web	41.350Inches $\pm$ 0.030	41.380 41.320		
20	Web	44.350Inches $\pm$ 0.030	44.380 44.320		
21	Web	47.400Inches $\pm$ 0.030	47.430 47.370		
22	Web	50.150Inches $\pm$ 0.030	50.180 50.120		
23	Web	52.900Inches $\pm$ 0.030	52.930 52.870		
24	Web	64.060Inches $\pm$ 0.030	64.090 64.030		
25	Web	70.270Inches $\pm$ 0.030	70.300 70.240		
26	Web	73.020Inches $\pm$ 0.030	73.050 72.990		
27	Web	75.770Inches $\pm$ 0.030	75.800 75.740		
28	Web	56.150Inches $\pm$ 0.030	56.180 56.120		

Plex 6/7/18 2:08 PM dart.white.jesse

